

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009566**Date Inspected:** 30-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 2F-070 located on PCMK SSD10A-PP86 of 10AW welder is identified as 202122. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 1F-063 located on PCMK SP775-001 of 10AW welder is identified as 066478. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2131.

FCAW welding of weld joint 3F-114 located on PCMK DP234-001 of 10CW welder is identified as 050316. ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

SMAW welding of weld joint 4G-016 located on PCMK SEG055A of 9BW welder is identified as 051348.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-Tc-U4b-FCM-1.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

SAW welding of weld joint 1G-007 located on PCMK SEG063\* of 10CW welder is identified as 045265.ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint 1G-004 located on PCMK SEG053\* of 9CW welder is identified as 045265.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

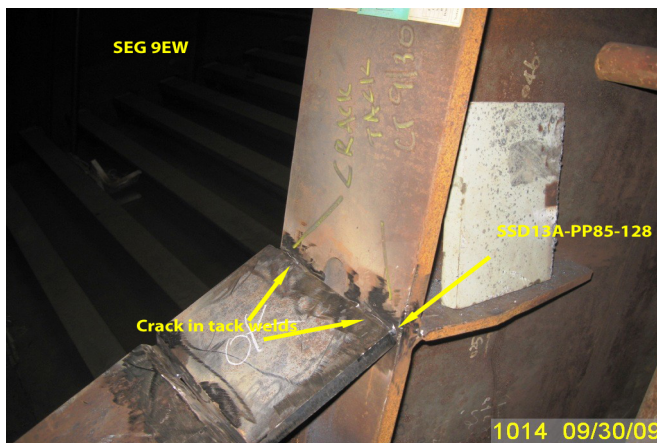
During visual inspection it is found that the fit up of the following connecting plate in between FL-1 and FL-2 cracks in tack welds and Notches on their bevels. It is informed to ABF QA Mr.Lihao and ZPMC QC is Mr.Xu tao. Photos attached.

SSD14A-PP77-128,198 of 9CW.  
SSD13A-PP78-134,128 of 9CW.  
SSD13A-PP85-128 of 9EW.  
SSD121A-PP94-011 of 10CW.

## OUTSIDE SEGMENTS

FCAW welding of weld joint 2G-004 located on PCMK SSD13-PP59 of 7EW welder is identified as 045280. ZPMC QC is identified as Mr.Zhang qiang. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-Repair and temporary WR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Item	Description
------	-------------

1	
---	--

2	
---	--

WBS	Dwg No.	Status
-----	---------	--------

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
----------------------	--------------	-----------------------------

---

<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------